

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014296**Date Inspected:** 12-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and TOWER COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Suspender Bracket SB70E , weld No. SB015-070-055. The welder is identified as #062749. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Suspender Bracket SB68E , weld No. SB015-068-037. The welder is identified as #062788. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Suspender Bracket SB62E , weld No. SB015-062-019. The welder is identified as #062738. ZPMC QC is identified as Mr. Zhoe Chang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

Bay #14

This QA Inspector observed the following work in progress:

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FCAW in the 2G position for the OBG Segment 12AW , weld No. SEG3004V-050. The welder is identified as #202122. ZPMC QC is identified as Mr. Zhoug Yong Gang. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G (2F)-REPAIR. The weld report is B-CWR-1504.

SMAW in the 3G position for the OBG Segment 11DW , weld No. SSEG071E-142. The welder is identified as #051348. ZPMC QC is identified as Mr. Tao Wei. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as Tower Façade.

Tower Façade weld No. Green Tag No.

SL3-18-001~007	12573
SL3-18-015~021	12574
SL3-23-001~007	12575
SL3-23-015~021	12576
SL3-28-001~007	12577
SL3-28-015~021	12578
SL3-33-001~007	12579
SL3-38-001~007	12581
SL3-38-015~021	12582
SL3-43-001~007	12583
SL3-43-015~021	12584
SL3-47.6-015~021	12585

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Tower Façade Pad Eye weld. This QA inspector generated a (MT) report for this date .This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SL3-18-18, 19
SL3-23-2, 17
SL3-28-15, 17, 21
SL3-33-6
SL3-38-2, 15
SL3-43-6, 8, 18
SL3-47.6-18

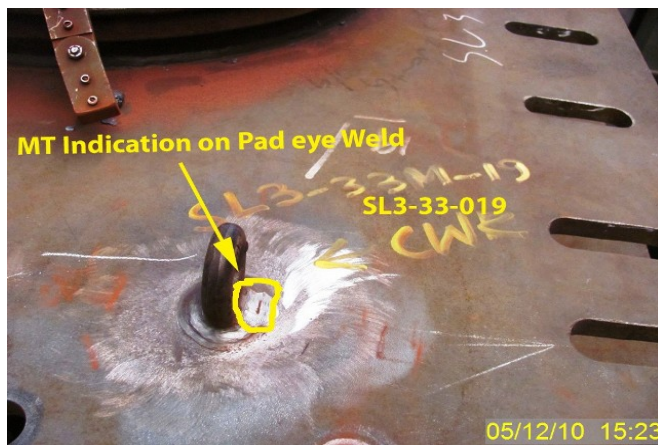
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During Quality Assurance Magnetic Particle Testing (MT) review of welds located on Tower Skin E-19- 33M Facade Pad Eye, this Quality Assurance (QA) Inspector discovered the following issues that One (1) longitudinal linear indication measuring approximately 12mm in length. The weld is identified as: SL3-33-019. The weld is located at Tower Skin E-19- 33M Facade plate. This weld is a Fillet Weld joining the Tower Facade (ND1-A262) to Pad Eye. This weld is designated as Non Seismic Performance Critical Member (Non SPCM). The Tower Façade is located at Bay #16 Work Shop. The Notice of Witness Inspection Number (NWIT) is 005719. The indication is located outside the area previously tested by ZPMC Quality Control (QC) personnel.

The QA inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer